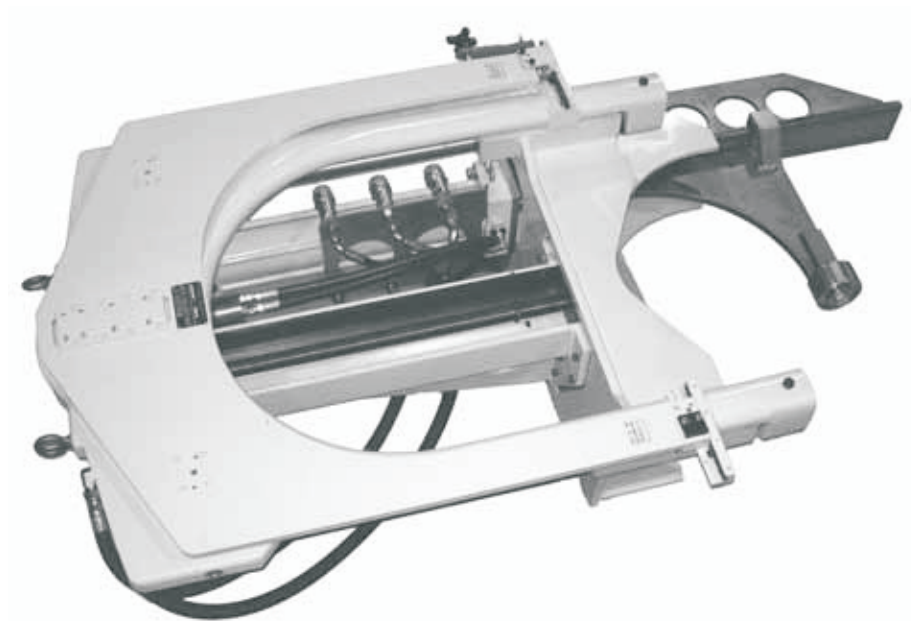




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Autoclamp/Autofeed Guillotine Super D Pipe Saw User's Manual

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Chapter 1

About This Manual

PURPOSE OF THIS MANUAL

This manual explains how to operate and maintain the Guillotine Super D Pipe Saw. It includes instructions for set-up, operation, and maintenance, with special instructions for the optional autoclamping and autofeed accessories. It also contains parts lists, diagrams, and service information to help you order replacement parts and perform user-serviceable repairs.

Before operating the Guillotine Pipe Saw, you should read through this manual and become familiar with all instructions. At a minimum, make sure you read and understand the following chapters:

- Chapter 1, About This Manual
- Chapter 2, Safety
- Chapter 3, Introduction to the Equipment
- Chapter 5, Operating Instructions
- Chapter 9, Accessories

If you will be performing service or repairs, make sure you read and understand these chapters:

- Chapter 1, About This Manual
- Chapter 4, Assembly and Disassembly
- Chapter 6, Routine Maintenance
- Chapter 7, Service and Repair.

In This Chapter

HOW TO USE THE MANUAL

SYMBOLS AND WARNINGS

MANUAL UPDATES AND
REVISION TRACKING

Throughout this manual, refer to this column for warnings, cautions, and notices with supplementary information.

You will also want to refer to Chapter 8, Parts Lists and Drawings.

HOW TO USE THE MANUAL

This manual is organized to help you quickly find the information you need. Each chapter describes a specific topic on using or maintaining your equipment.

Each page is designed with two columns. This large column on the inside of the page contains instructions and illustrations. Use these instructions to operate and maintain the equipment.

The narrower column on the outside contains additional information such as warnings, special notes, and definitions. Refer to it for safety notes and other information.

SYMBOLS AND WARNINGS

The following symbols are used throughout this manual to indicate special notes and warnings. They appear in the outside column of the page, next to the section they refer to. Make sure you understand what each symbol means, and follow all instructions for cautions and warnings.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



NOTE

This symbol indicates a user notice. **Notices** provide additional information to supplement the instructions, or tips for easier operation.

MANUAL UPDATES AND REVISION TRACKING

Occasionally, we will update manuals with improved operation or maintenance procedures, or with corrections if necessary. When a manual is revised, we will update the revision history on the title page.

You may have factory service or upgrades performed on the equipment. If this service changes any technical data or operation and maintenance procedures, we will include a revised manual when we return the equipment to you.

Current versions of E.H. Wachs Company manuals are also available in PDF format. You can request an electronic copy of this manual by emailing customer service at sales@wachSCO.com.

Chapter 2

Safety

.....

The E.H. Wachs Company takes great pride in designing and manufacturing safe, high-quality products. We make user safety a high priority in the design of all our products.

Read this chapter carefully before operating the Guillotine Super D pipe saw. It contains important safety instructions and recommendations.

OPERATOR SAFETY

Follow these guidelines for safe operation of the equipment.

- **READ THE OPERATING MANUAL.** Make sure you understand all setup and operating instructions before you begin.
- **INSPECT MACHINE AND ACCESSORIES.** Before starting the machine, look for loose bolts or nuts, leaking lubricant, rusted components, and any other physical conditions that may affect operation. Properly maintaining the machine can greatly decrease the chances for injury.
- **ALWAYS READ PLACARDS AND LABELS.** Make sure all placards, labels, and stickers are clearly legible and in good condition. You can purchase replacement labels from E.H. Wachs Company.
- **KEEP CLEAR OF MOVING PARTS.** Keep hands, arms, and fingers clear of all rotating or moving parts.

In This Chapter

OPERATOR SAFETY

SAFETY LABELS

MACHINE SAFETY

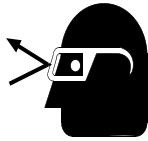


Look for this symbol throughout the manual. It indicates a safety warning.

Always turn machine off before doing any adjustments or service.

- **SECURE LOOSE CLOTHING AND JEWELRY.** Secure or remove loose-fitting clothing and jewelry, and securely bind long hair, to prevent them from getting caught in moving parts of the machine.
- **KEEP WORK AREA CLEAR.** Keep all clutter and nonessential materials out of the work area. Only people directly involved with the work being performed should have access to the area.
- **DO NOT OPERATE IN POTENTIALLY EXPLOSIVE ENVIRONMENTS.** The Guillotine saw can create sparks, which can cause an explosion in the presence of flammable or explosive materials.

Protective Equipment Requirements

	WARNING Always wear impact resistant eye protection while operating or working near this equipment.
--	---

For additional information on eye and face protection, refer to Federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.133., Eye and Face Protection and American National Standards Institute, ANSI Z87.1, Occupational and Educational Eye and Face Protection. Z87.1 is available from the American National Standards Institute, Inc., 1430 Broadway, New York, NY 10018.

	CAUTION Personal hearing protection is recommended when operating or working near this tool.
---	--

Hearing protectors are required in high noise areas, 85 dBA or greater. The operation of other tools and equipment in the area, reflective surfaces, process noises, and resonant structures can increase the noise level in the area. For additional information on hearing protection, refer to Federal OSHA

regulations, 29 Code of Federal Regulations, Section 1910.95, Occupational Noise Exposure and ANSI S12.6 Hearing Protectors.

SAFETY LABELS

There are two safety labels on the Super D Guillotine saw. These are illustrated in Figure 2-1 and Figure 2-2.



Figure 2-1. Observe the warning label for moving parts hazards.



Figure 2-2. Observe the warning label for blade hazard.

MACHINE SAFETY

To avoid damaging the Guillotine Super D, follow these usage guidelines.

- Do not exceed 1800 psi hydraulic pressure.
- Lubricate the machine according to the recommendations in Chapter 6.
- Before starting the machine, make sure the feed drive is retracted so that the blade is not in contact with the surface being cut.

Chapter 3

Introduction to the Super D Pipe Saw

Read this chapter carefully to become familiar with the components of the Guillotine Super D pipe saw.

USAGE AND APPLICATIONS

The Guillotine Super D pipe saw is designed for cold-cutting pipes of any material from 10" to 24" diameter, as well as solids such as bar stock and rails. The saw has a "V"-saddle base that ensures square alignment with the workpiece, and an autoclamping mechanism to simplify installation on the workpiece. The Guillotine Super D will cut approximately one diameter inch per minute.

The reciprocating motion of the Guillotine saws lifts the blade from the cut on the return stroke, greatly increasing blade life. Blades are easily changed out when worn.

Guillotine saws are available for hydraulic, electric, and pneumatic power sources. Available accessories include hydraulic autoclamping for fast setup in difficult environments (such as underwater cutting) and adjustable autofeed for automated cutting.

MECHANICAL OVERVIEW

Figure 3-1 and Figure 3-2 illustrate the mechanical components of the Super D pipe saw. Figure 3-3 shows the

In This Chapter

USAGE AND APPLICATIONS

MECHANICAL OVERVIEW

MACHINE SPECIFICATIONS

OPERATING ENVELOPE

hydraulic connector bulkhead. Refer to them during set-up instructions for identifying the parts of the machine.

The topside control unit (TCU), which is used for control of the Super D saw, is shown in Figure 3-4.

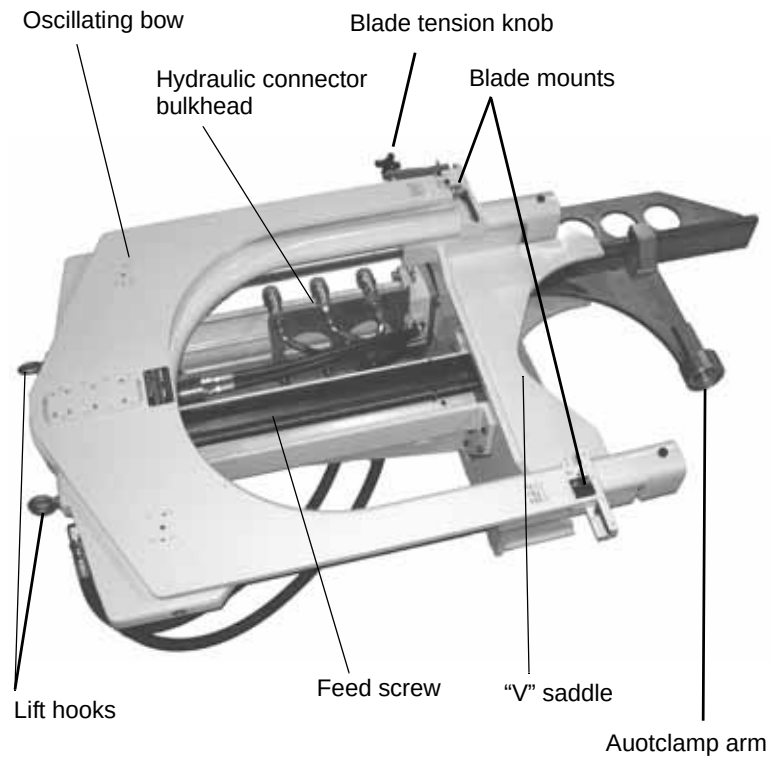


Figure 3-1. The photo illustrates the mechanical components of the Super D pipe saw.

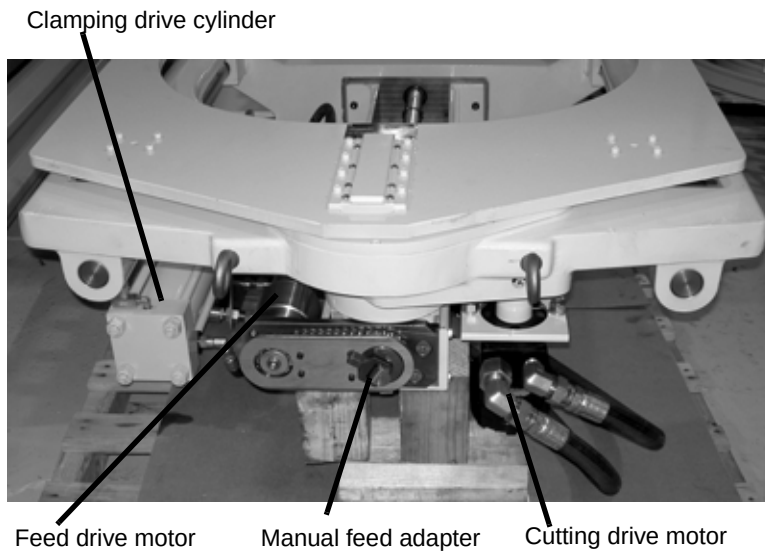


Figure 3-2. The Super D drive components are illustrated.

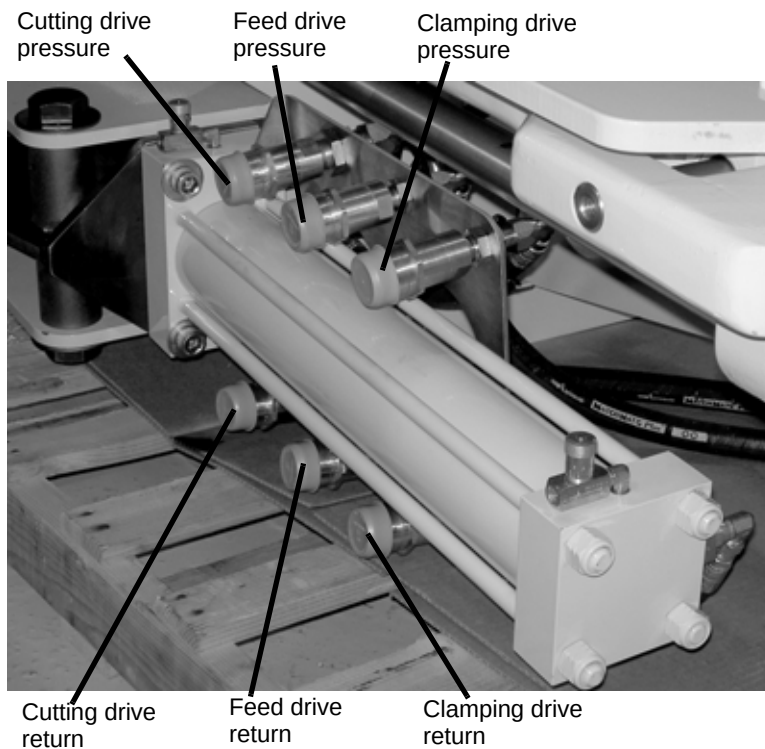


Figure 3-3. The photo shows the hydraulic connector bulkhead.

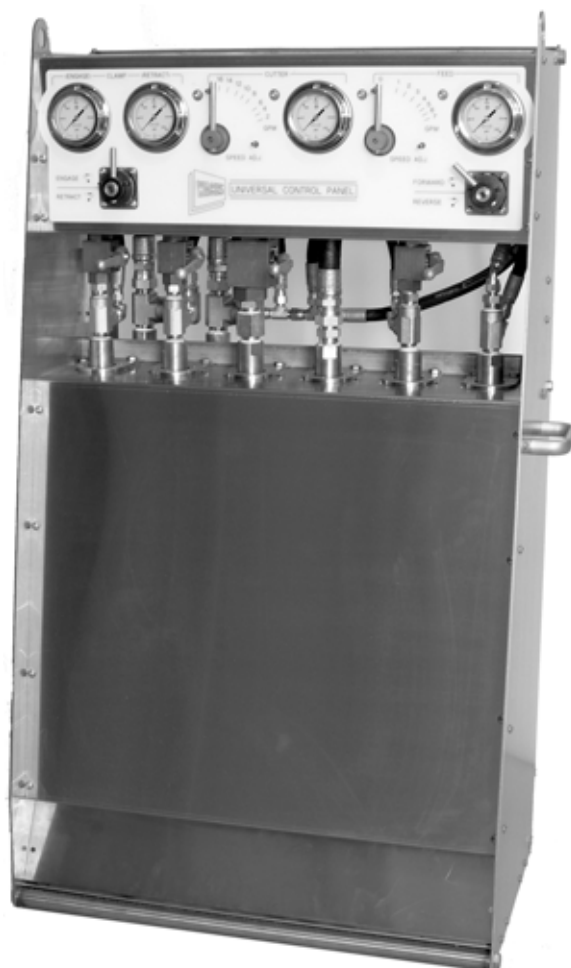


Figure 3-4. The photo shows the topside control unit.

MACHINE SPECIFICATIONS

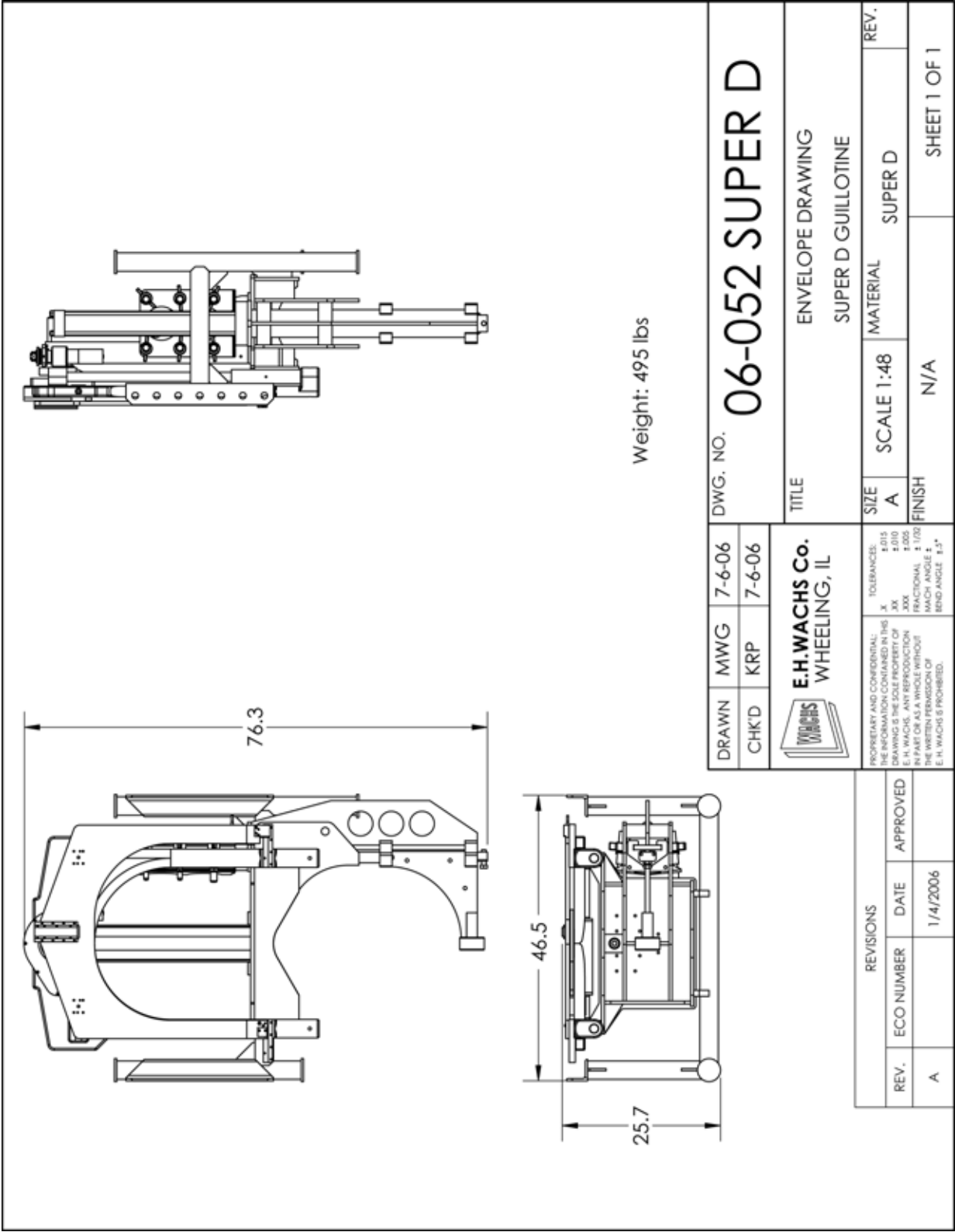
The following specifications are for the Guillotine Super D with autofeed and autoclamping accessories installed.

Capacity:	10"-24" (254-610 mm) diameter pipe; solids up to 24-1/2" (622 mm)
Drive:	Hydraulic, 15 gpm @ 1800 psi
Length:	76.3" (1938 mm)
Width:	45" (1143 mm)
Height:	25.7" (653 mm)
Weight:	1500 lb (682 kg) operating 1571 lb (714 kg) shipping

Lubrication:	Grease fittings at all wear points; auto-clamp rail
Finish:	Paint
Blades:	General purpose and heavy duty
Feed rate:	Variable up to 1" per minute
Noise level:	72 dBA (continuous A-weighted sound pressure at work station) 90 dBA (peak C-weighted maximum sound pressure) 86 dBA (sound power level emitted by machine)

OPERATING ENVELOPE

The following drawing shows the operating envelope and required clearances for using the Super D saw.



Chapter 4

Assembly, Disassembly, and Storage

The Guillotine Super D pipe saw is factory assembled and ready for set-up. The machine is skidded and crated for shipping and storage.

ENVIRONMENTAL REQUIREMENTS

The Guillotine Super D pipe saw can be used in any industrial or field service environment, including underwater. The machine can be used for dry cutting or with coolant applied to the workpiece.

LONG-TERM STORAGE

If you will be storing the Guillotine Super D, take the following steps to prepare it:

- Reverse the feed drive to the end of travel.
- Remove the blade.
- Make sure the machine is thoroughly cleaned and cleared of chips and debris.
- Spray the machine with a rust preventative.
- Grease all fittings according to the instructions in Chapter 6.

In This Chapter

ENVIRONMENTAL
REQUIREMENTS

LONG-TERM STORAGE

SHIPPING

SHIPPING

The Guillotine Super D pipe saw is shipped on a skid. To ship the machine, skid it and strap it securely as you would any industrial machinery.

Chapter 5

Operating Instructions

The Guillotine pipe saw can be installed on a pipe in any orientation—horizontal, vertical, or at an angle. Once the saw is clamped into place, you will release tension on the lift to allow the clamping mechanism to support the saw.

Refer to Chapter 3 if necessary for identification of the machine’s components. The Super D is operated from the topside control unit (TCU); fig shows the instruction panel on the top of the TCU.

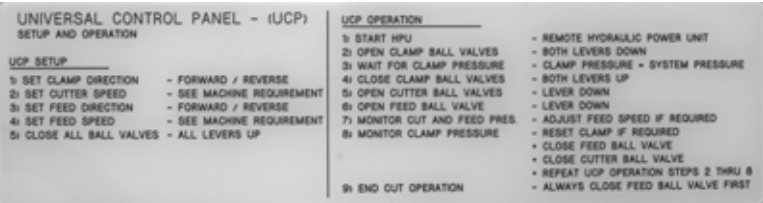


Figure 5-1. The instruction label on top of the TCU provides brief instructions for operating the saw.

MACHINE SET-UP

Before lifting the Guillotine Super D, make sure the feed drive is at its starting point. (The saw bow should be retracted all the way back from the V saddle.) Ensure that the blade is sharp; install a new blade if necessary (see Chapter 6 for instructions).

In This Chapter

- MACHINE SET-UP
- OPERATION
- REMOVING THE SAW

Positioning the Saw

1. Attach a lift to the lift hooks at the top of the frame. If you will be setting up the saw vertically (cutting a horizontal pipe), you can lift it into place using just the two lift hooks.

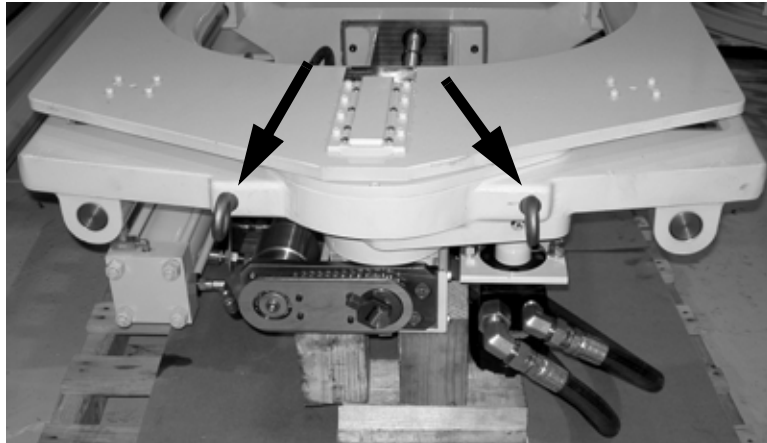


Figure 5-2. There are two lift hooks at the top of the saw frame.

2. If you will be using the saw in a horizontal or angled position (cutting a pipe that is not horizontal), you will need to attach lift straps to the other end of the saw frame, as illustrated in Figure 5-3. Adjust the length of the strap to hold the saw at the required angle.

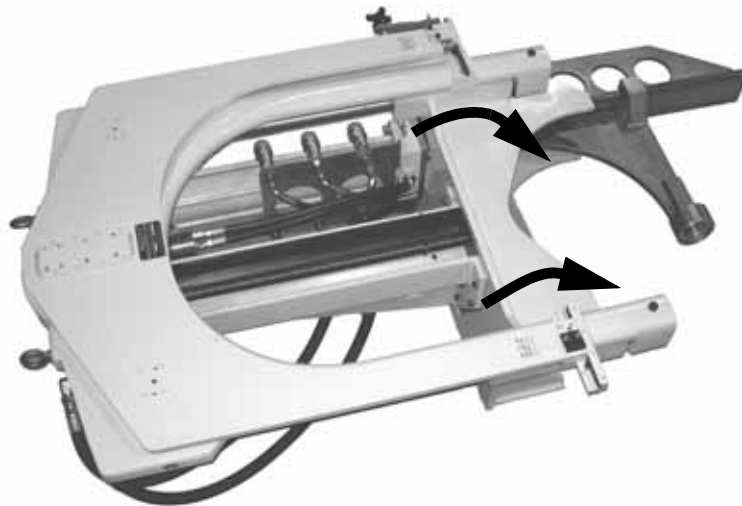


Figure 5-3. If you are positioning the saw horizontally or at an angle, use the lift hooks and also attach lift straps around the frame at the locations shown.

CAUTION: Before cutting with the saw, make sure you remove the lifting strap from the frame—after clamping the saw in place. Keep the lift attached to the lift hooks.



CAUTION: Make sure the lift strap does not bind against the saw blade or the oscillating bow.

3. Lift the saw carefully, positioning the lift so that it is over the center of gravity as you pick it up. If you are lifting from the top of the saw and the other end starts to slide, stop and reposition the lift.
4. Move the saw into position on the pipe so that the V saddle is against the pipe at the cut position. The saw should be close to square with the pipe; the clamping mechanism will precisely square it.

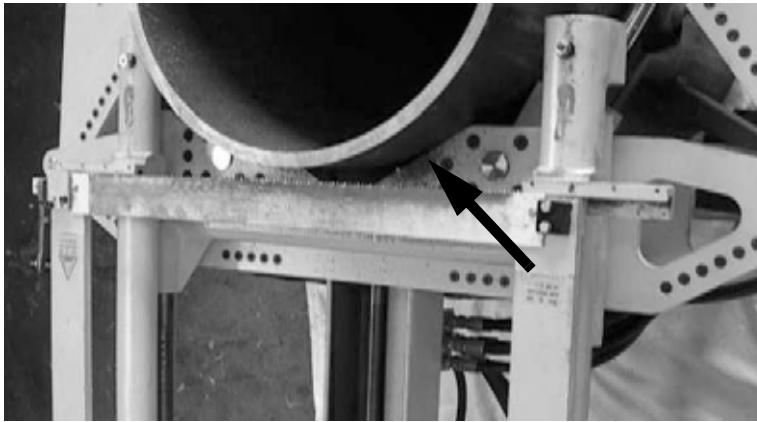


Figure 5-4. Position the saw so that both touch points of the V saddle are against the pipe. (The photo shows the touch point on one side.)

Connecting the Hoses

1. Wipe all hose couplers with a clean, lint free cloth before making connections.
2. Connect the hoses from the hydraulic power unit (HPU) to the HPU fittings on the back of the topside control unit (TCU).



WARNING:

The saw may slide or shift abruptly when it is lifted.

Proceed slowly and reposition the lift if necessary to keep it over the saw's center of gravity.

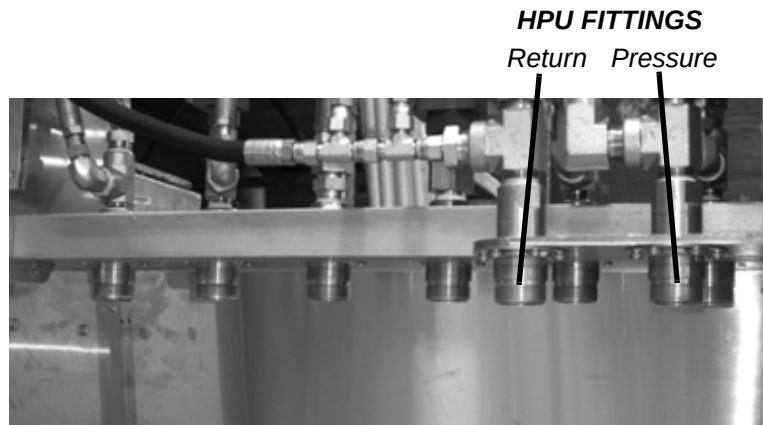


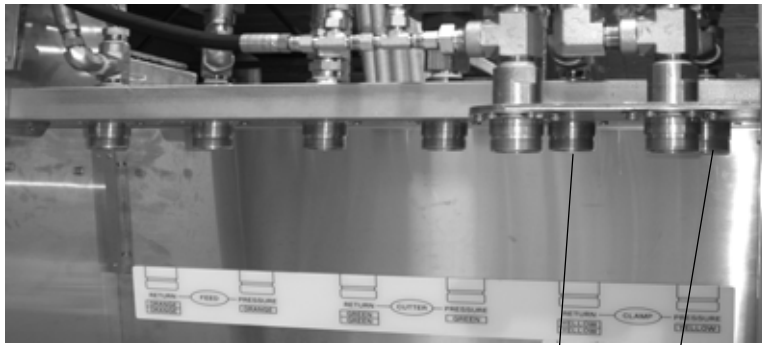
Figure 5-5. HPU hose fittings on the back of the control unit.

3. Connect the cutting drive hose set from the machine or from the hose reel to the cutting drive fittings on the back of the TCU. The hoses and fittings are color coded.



Figure 5-6. Connect the cutting drive hoses to the TCU.

4. If the machine has a hydraulic clamping mechanism, connect the clamping drive hose set to the clamping drive fittings on the back of the TCU. The hoses and fittings are color coded.



Return Pressure
CLAMPING DRIVE

Figure 5-7. Connect the clamping drive hoses to the TCU (for machines with hydraulic clamping mechanism).

5. Connect the feed drive hose set from the machine or from the hose reel to the feed drive fittings on the back of the TCU.



Return Pressure
FEED DRIVE

Figure 5-8. Feed drive connectors (for machines with hydraulic feed drives).

6. Connect the hoses from the TCU or hose reel to the fittings on the saw bulkhead as shown in Figure 5-9.

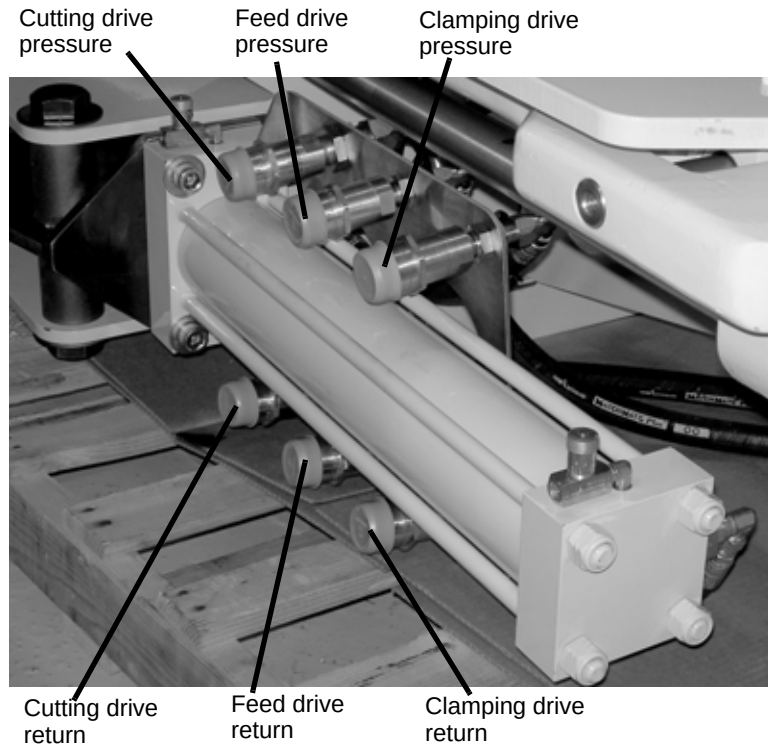


Figure 5-9. Connect the clamping drive hoses to the saw as shown.

Clamping the Saw to the Workpiece

1. Position the saw at the cutting location on the pipe, with the saddle against the pipe surface.
2. Start the hydraulic power unit.
3. Make sure that the clamping drive levers and the cutting drive lever on the TCU are in the closed (up) position, as shown in Figure 5-10.
4. Set the clamping direction lever on the TCU to the ENGAGE position.

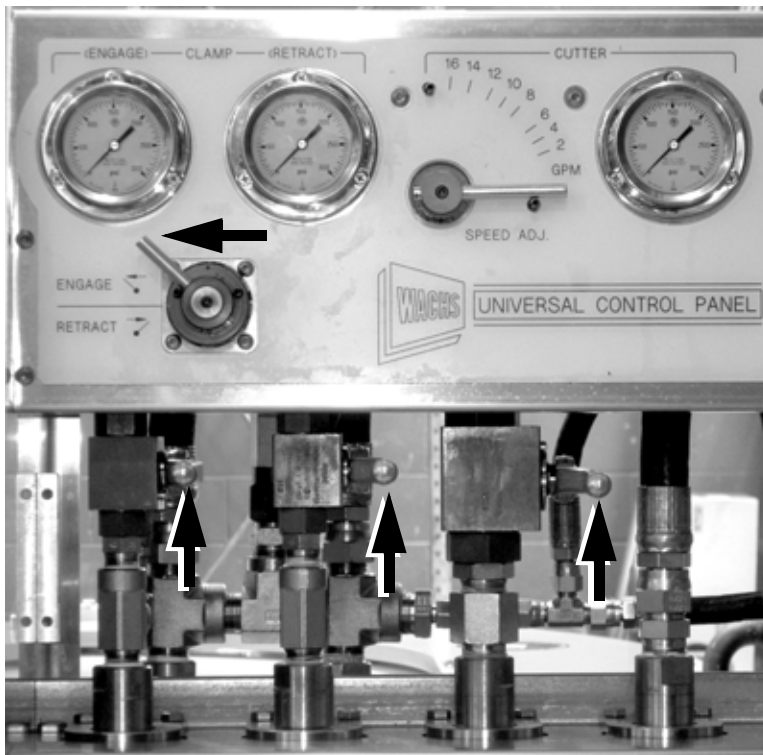


Figure 5-10. Before clamping, make sure that both clamping levers and the cutting lever are in the up position, and that the clamping direction lever is in the ENGAGE position.

5. Open both clamping drive levers (down position) at the same time to engage the autoclamp drive. When the clamp pressure equalizes with the system pressure, the clamp is fully engaged against the pipe.

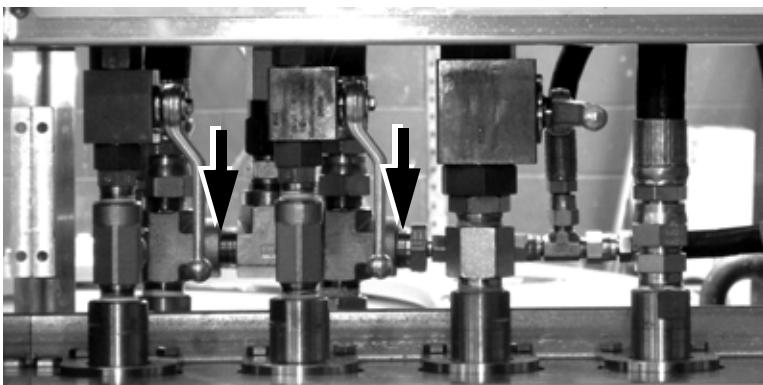


Figure 5-11. Put both clamping levers down at the same time to engage the clamping drive.

6. Close both clamping drive levers (up position) at the same time. The valves will hold pressure on the clamping drive to keep the saw clamped on the pipe.

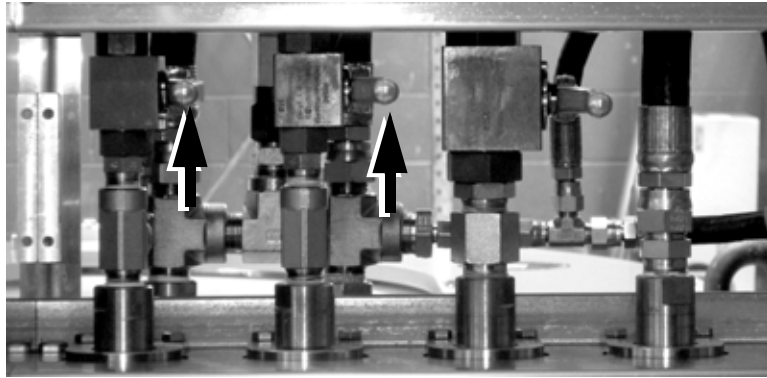


Figure 5-12. When the clamping drive is fully engaged (clamping pressure equals system pressure), return both clamping levers to the up position.

7. Slightly lower the crane holding the saw to allow the clamp to hold the saw's weight. Leave the crane attached to the saw.

CAUTION: Make sure the pipe is supported securely on both sides of the saw.



WARNING: Make sure all personnel and loose objects are clear of the machine during cutting.



OPERATION

Using coolant during cutting is recommended to increase blade life and make cutting easier.

Make sure that the pipe being cut is supported securely on both sides of the saw.

1. Make sure the cutting drive speed control lever is set to 0.



Figure 5-13. Set the cutting drive speed lever to 0 before starting the saw.

2. Open the cutting drive lever (down position).

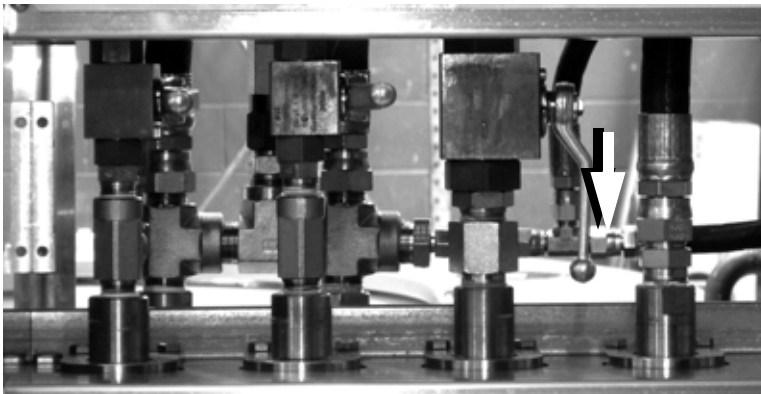


Figure 5-14. Push the cutting drive lever down to open it.

3. Move the cutting drive speed lever up gradually. When sufficient flow reaches the saw, the saw bow will begin the cutting motion.



Figure 5-15. Push the cutting speed lever up slowly until the saw motion begins.

4. Set the feed direction lever to the FORWARD position, as shown in Figure 5-16.
5. Open the feed drive lever by pushing it down.
6. Adjust the feed speed lever until the feed motion starts. Set the lever to the desired speed.

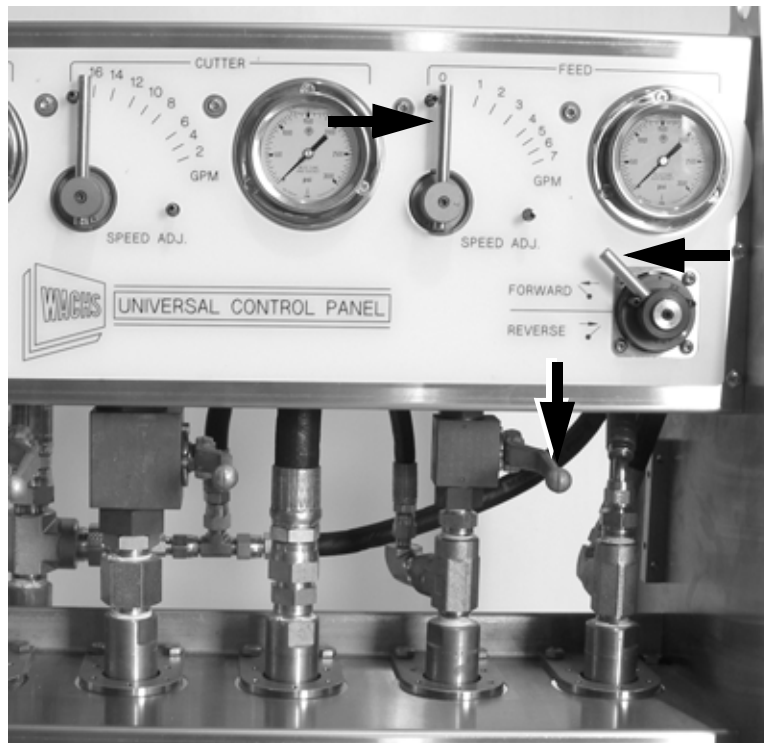


Figure 5-16. With the feed direction lever in the FORWARD position, move the feed drive lever (shown here in the up position) down to start the drive. Then move the feed speed lever to start flow to the feed drive.

7. Set the cutting drive lever for the speed you want. Typically, you can set it to the maximum.



Figure 5-17. Set the cutting speed lever to the desired cutting speed.

8. Allow the saw to operate at a slow feed rate until the blade has parted through the near wall of the pipe.

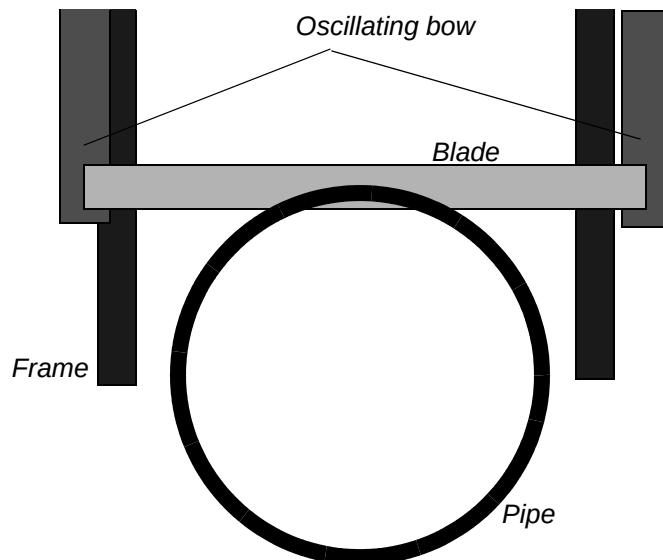


Figure 5-18. Cut at a slow feed rate until the blade parts through the wall of the pipe.

9. After the blade has parted the near wall, you can speed up the feed rate by adjusting the feed speed lever. You may need to slow the rate down if you are cutting an internal casing. Reduce the feed speed if the machine starts to bind or chatter, or if you see the blade deflecting as it cuts.
10. As the blade approaches the far wall of the pipe, slow the feed rate to the setting used at the start. Finish the cut at this feed rate.

11. When the cut is complete, move the feed speed lever back to 0 to stop the feed motion.

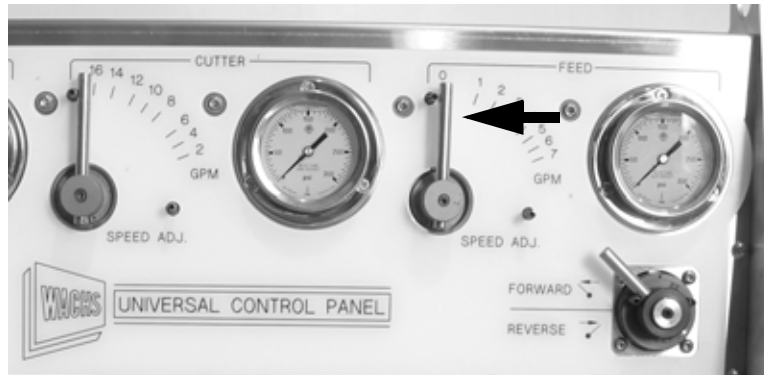


Figure 5-19. Stop the feed motion by setting the feed speed lever back to 0.

12. Move the feed drive lever back to the up position.

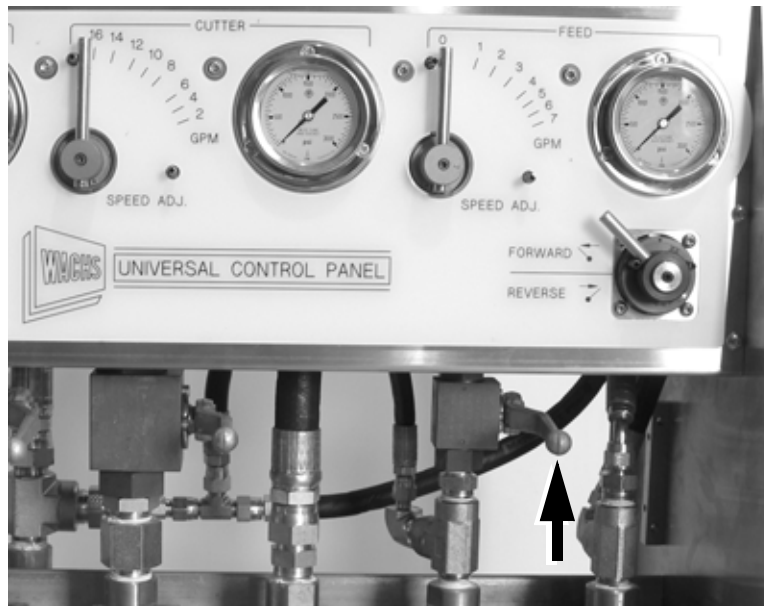


Figure 5-20. Move the feed drive lever up to stop the feed motion.

13. Set the cutting speed lever back to 0, and pull the cutting drive lever back up to the off (up) position.

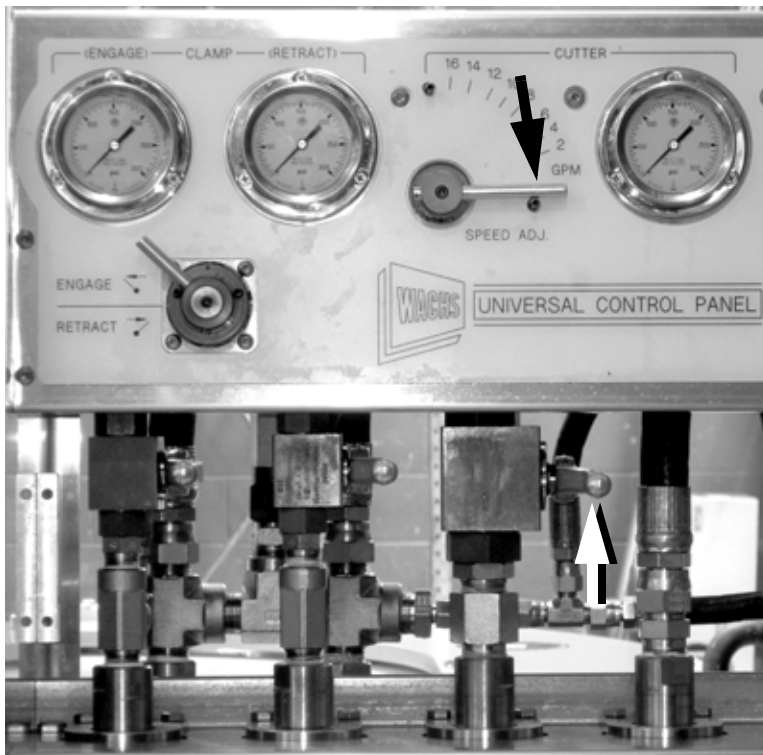


Figure 5-21. When the cut is complete, set the cutting speed lever back to 0. Then return the cutting drive lever to the off (up) position.

14. To reverse the feed and move the saw bow back to the start position, set the feed direction lever to the REVERSE position and use the feed drive lever to operate the drive. You may have to remove the blade first to prevent it from binding on the pipe.

REMOVING THE SAW

1. Slowly raise the lift holding the saw until there is just enough tension to hold the saw in place.
2. Set the clamping direction lever to the RETRACT position.



Figure 5-22. Set the clamping direction lever to the RETRACT position.

3. Open both clamping drive levers (down position) at the same time to retract the autoclamp drive. When the clamp pressure equalizes with the system pressure, the clamp is fully retracted.

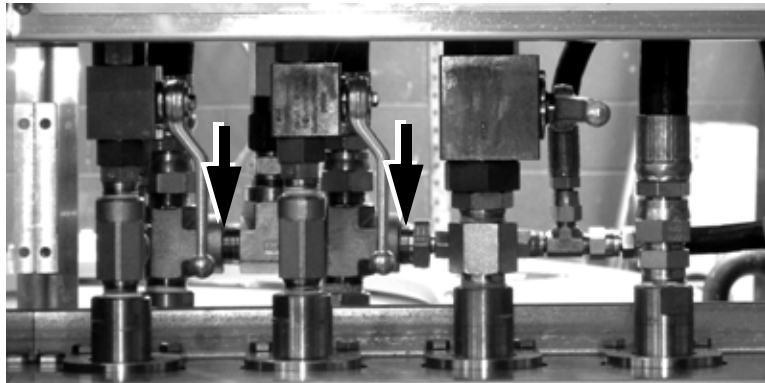


Figure 5-23. Put both clamping levers down at the same time to retract the clamping drive.

4. Close both clamping drive levers (up position) at the same time.

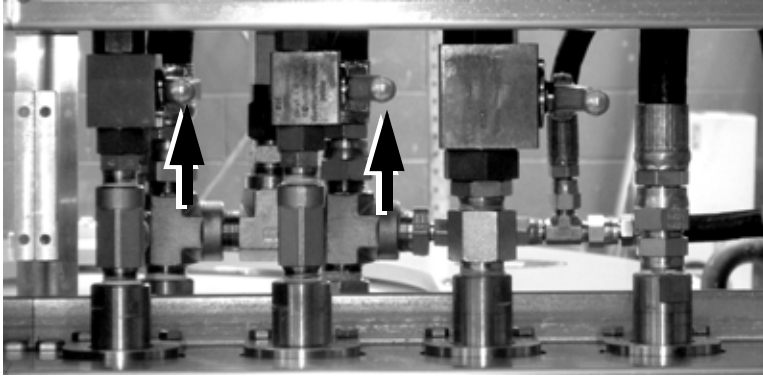


Figure 5-24. When the clamping drive is fully retracted (clamping pressure equals system pressure), return both clamping levers to the up position.

5. Set the clamping direction lever back to the ENGAGE position for the next operation.



Figure 5-25. When the clamp has been retracted, move the clamping direction lever back to the ENGAGE position.

6. Use the crane to remove the saw from the workpiece.
7. If you are finished with the saw, turn off the HPU. Set the saw in its storage location and disconnect the hoses.

Chapter 6

Routine Maintenance

LUBRICATION

1. Grease all fittings on the Guillotine frame every day before using the saw. There are 7 grease fittings on the machine, as shown in the following figures. Use a high-quality grade of soft grease.

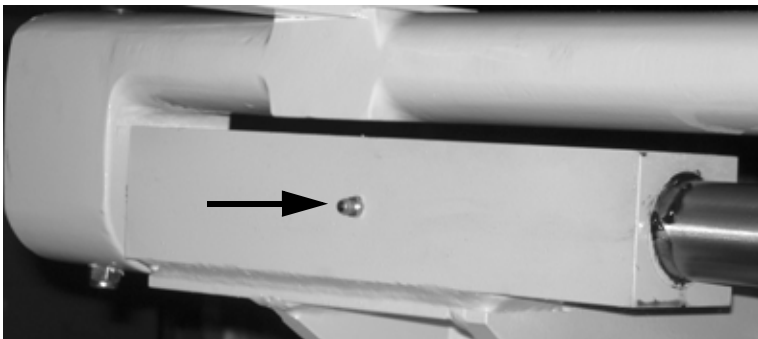


Figure 6-1. Grease the frame guides; there are two fittings, one on each side of the machine.

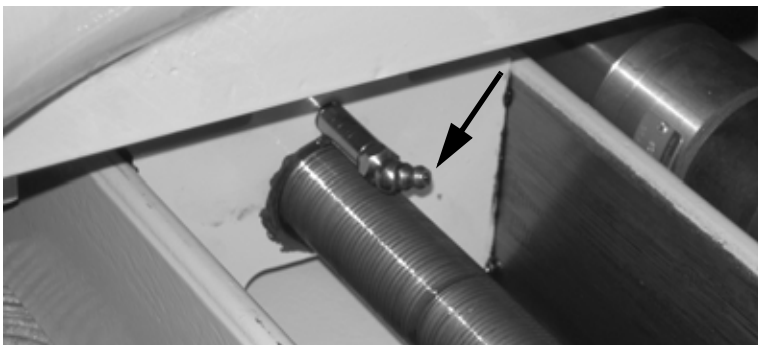


Figure 6-2. Grease the feed screw.

In This Chapter

LUBRICATION

BLADE REPLACEMENT

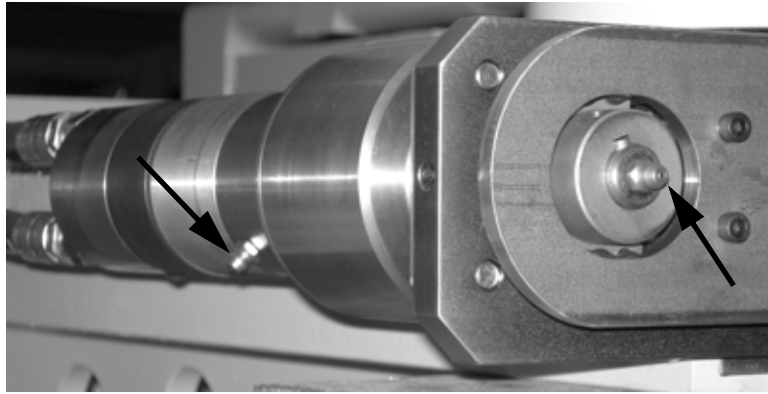


Figure 6-3. Grease the two fittings on the feed drive motor and gear.

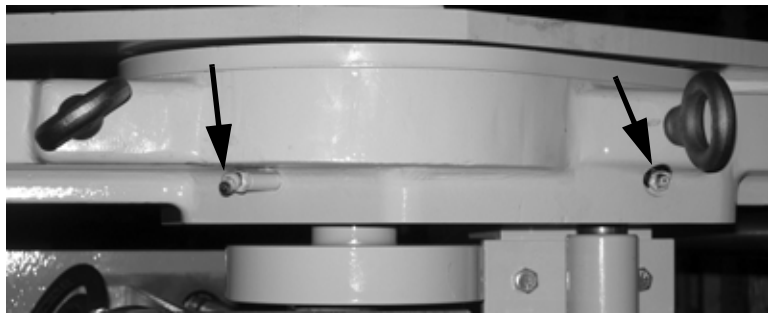


Figure 6-4. Grease the two fittings on the cutting gear housing.

2. Grease the clamp drive rail every day of use.

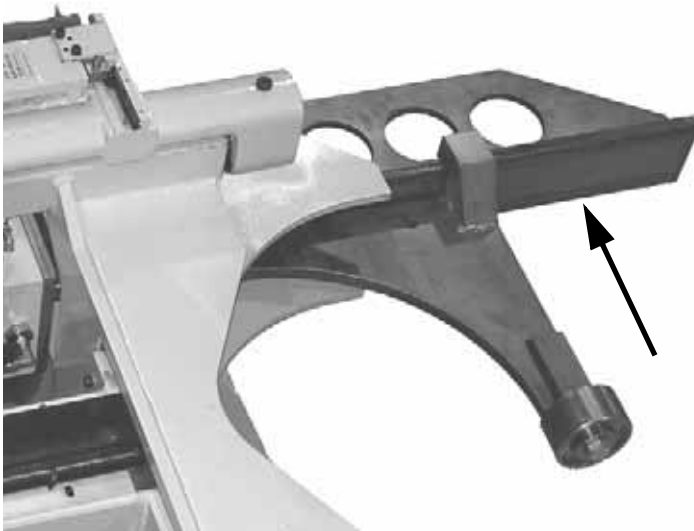


Figure 6-5. Apply grease to the top and bottom of the clamp drive rail.

BLADE REPLACEMENT

Check the sharpness of the blade after each cutting operation. Replace blades using the following procedure.

1. Return the saw bow to its fully retracted position using the rapid reverse autofeed or using the drive wheel in manual mode.
2. Loosen the blade by turning the blade tension knob counterclockwise.
3. Pull the blade off the mounting pins.
4. Insert the new blade onto the mounting pins. Make sure the teeth point to the left as you face the machine. (See the blade direction labels on the saw bow.)
5. Turn the blade tension knob clockwise until the blade is taut.



WARNING:
Use gloves to remove the worn blade. There may be sharp metal fragments on the blade.

Chapter 7

Service and Repair

.....

The Guillotine Super D saw is a durable system with little required maintenance.

There are no user-serviceable components on the machine (except for replacement of the blade). Contact the E.H. Wachs Company if service is required. (See Chapter 10, “Ordering Information”.) Any service must be performed by a factory-authorized service representative.

Chapter 8

Parts Lists and Drawings

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Refer to the parts lists and associated drawing in this chapter for ordering and maintenance.

There are separate part listings for Guillotine Super D auto-clamp machine and for the autofeed and lifting frame accessories. Call service at (800) 323-8185 for assistance in ordering.

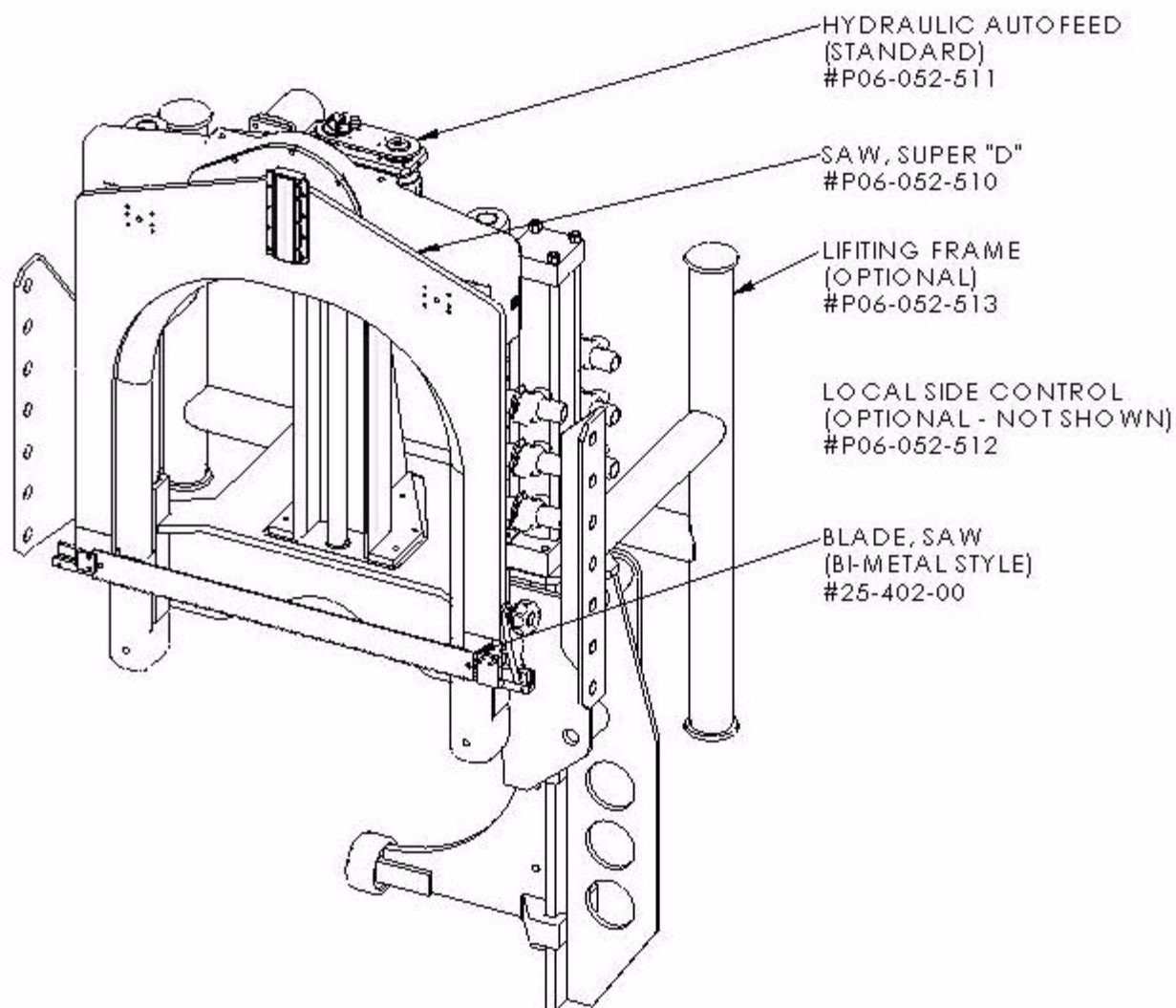
DRAWINGS

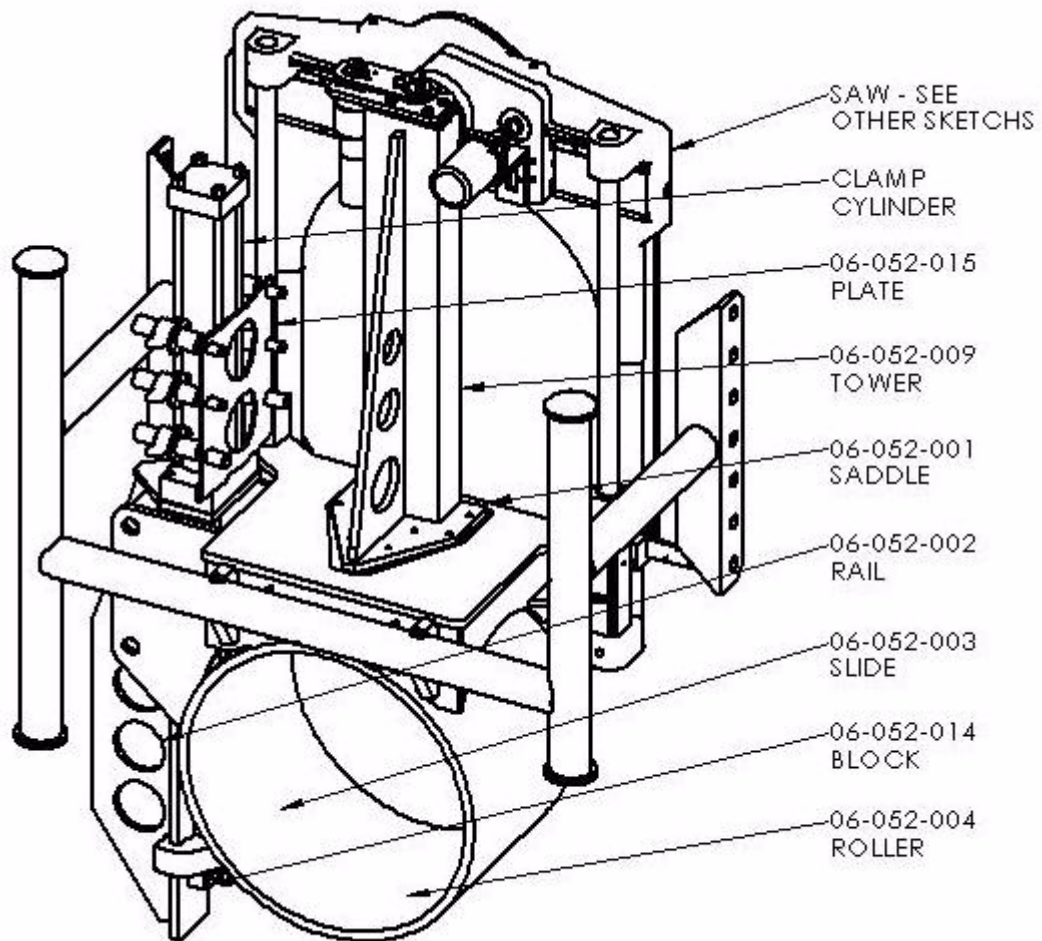
The following drawings illustrate the Super D Guillotine's components. Refer to the Parts List for part descriptions.

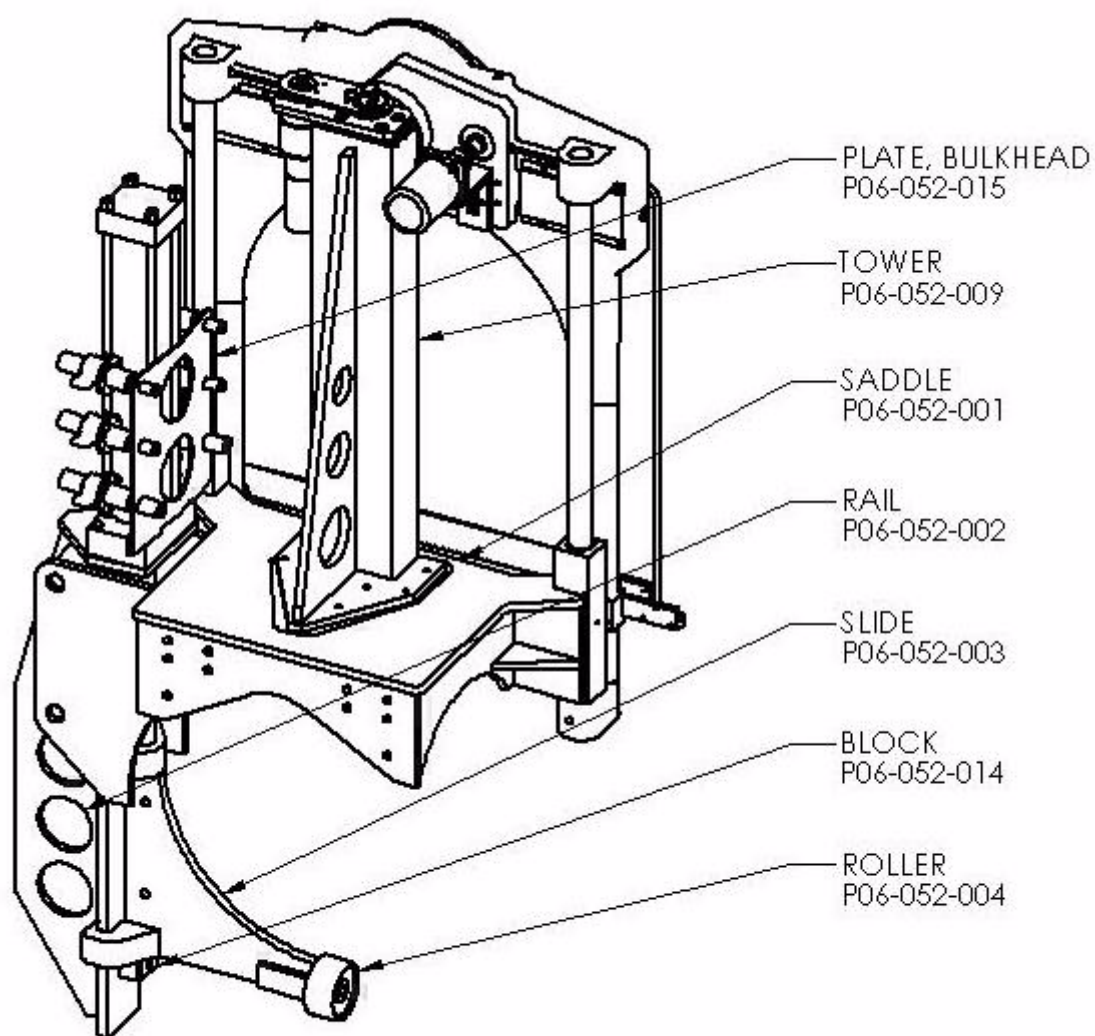
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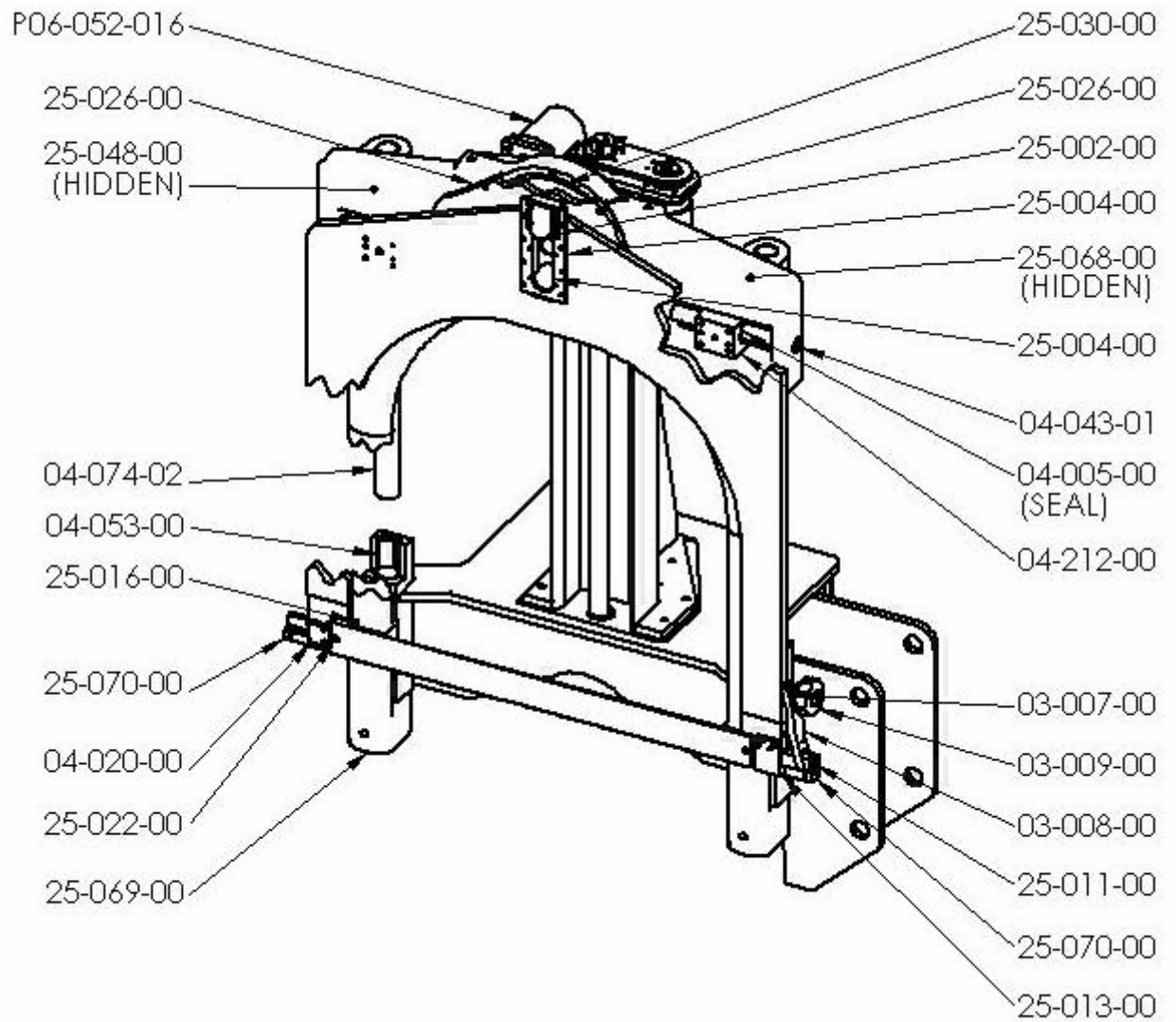
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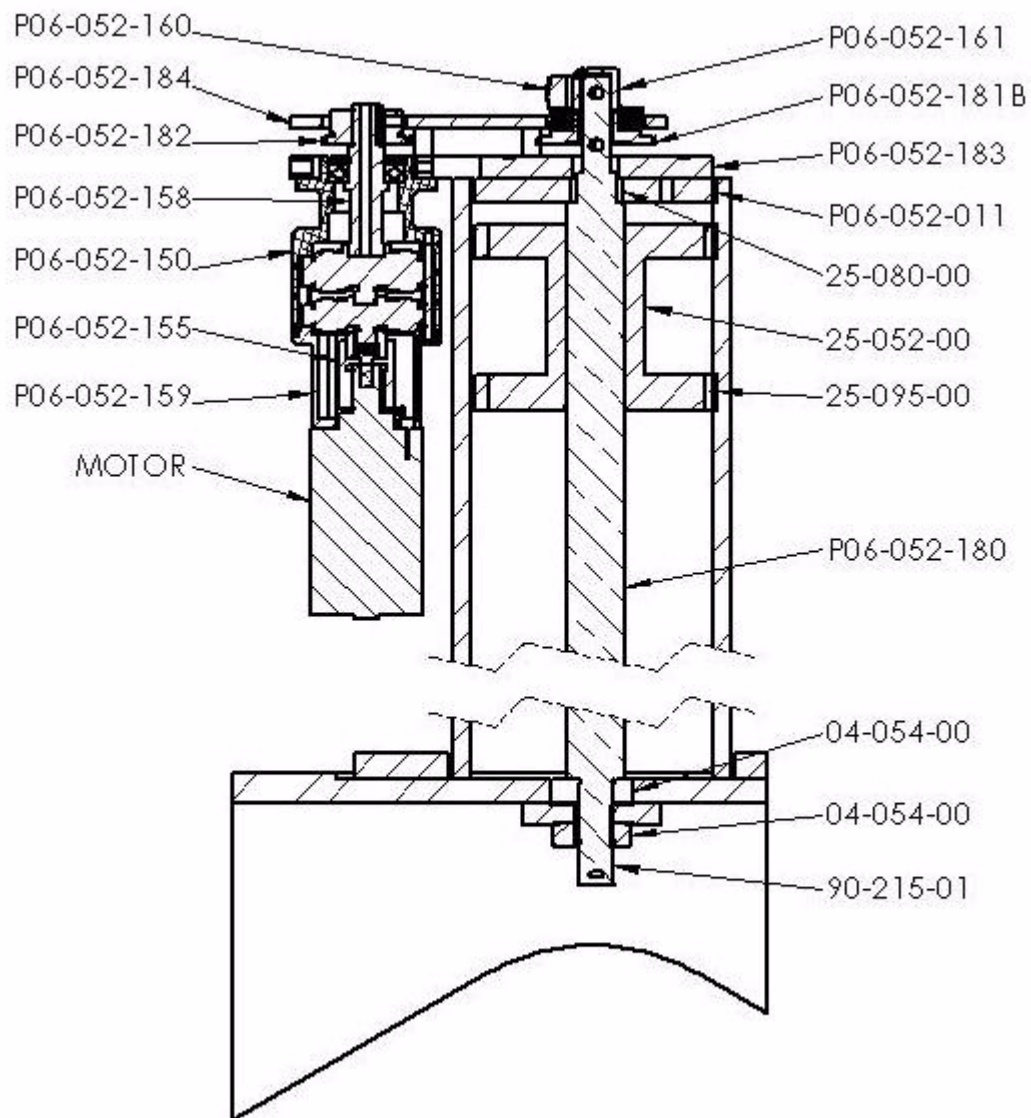
PARTS LIST

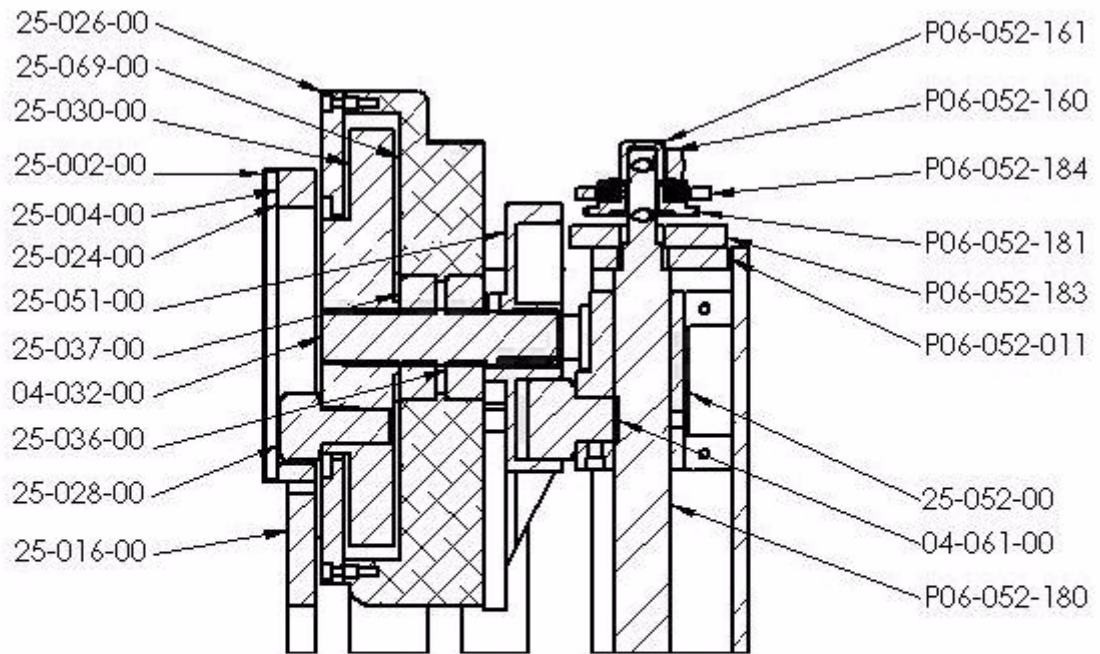




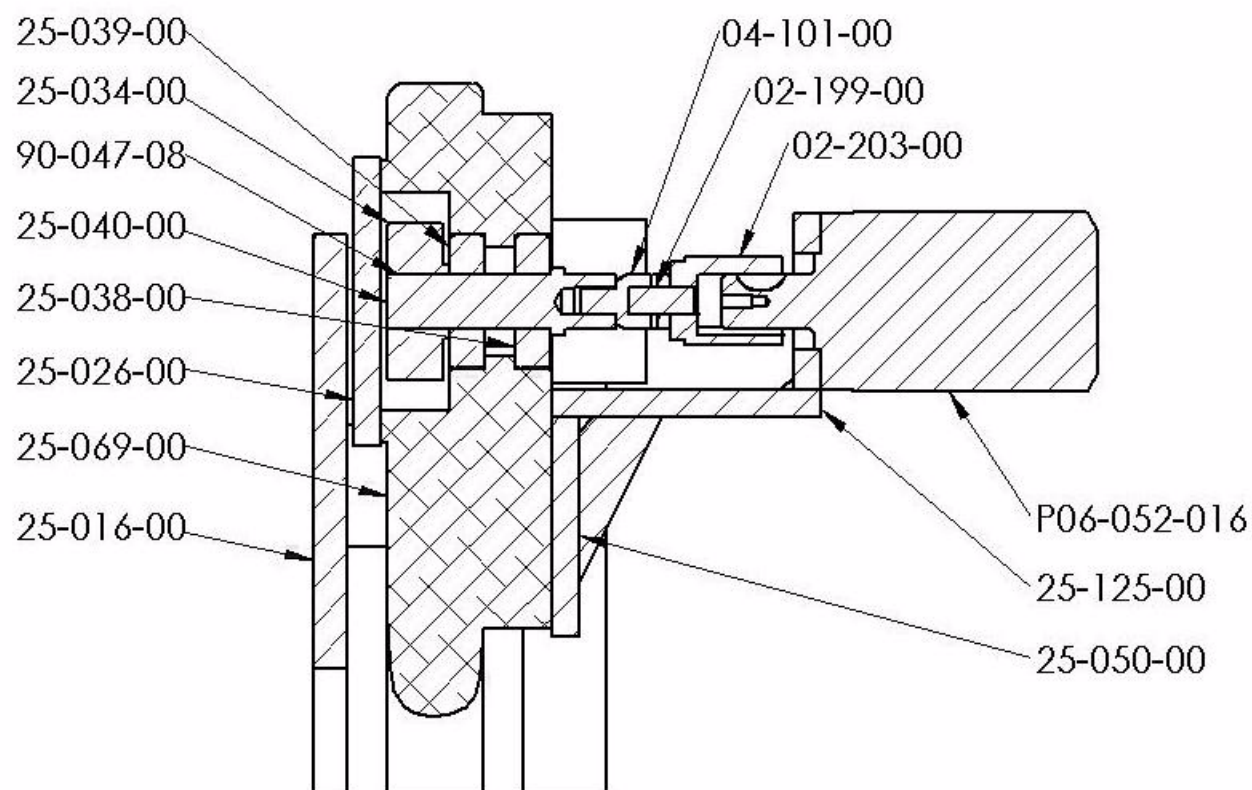








SECTION C-C
SCALE 1:4



PARTS LIST

P06-052-510 AUTOCLAMPING MODEL SUPER D		
Quantity	Part No.	Description
1	P06-052-001	SADDLE
1	P06-052-002	RAIL
1	P06-052-003	SLIDE
1	P06-052-004	ROLLER
1	P06-052-009	TOWER
1 REF.	P06-052-010	WELDMENT, TOWER
1	P06-052-011	PLATE, BEARING
1	P06-052-014	BLOCK, SUPER D RAIL LOCKDOWN
1	P06-052-015	PLATE, BULKHEAD MOUNTING
1 REF	P06-052-300	PLATE, SADDLE TOP
1 REF	P06-052-301	PLATE, SADDLE FRONT
2 REF	P06-052-302	PLATE, SADDLE CLAMPING
1 REF	P06-052-303	PLATE SADDLE REAR
1 REF	P06-052-304	BLOCK, SADDLE BEARING
2 REF	P06-052-305	PLATE, SADDLE GUSSET 1
1 REF	P06-052-306	PLATE, SADDLE SIDE
2 REF	P06-052-307	PLATE, SADDLE GUSSET 2
1 REF	P06-052-308	PLATE, SADDLE GUSSET 3
2 REF	P06-052-309	BLOCK, SADDLE SHAFT SUPPORT
1 REF	P06-052-310	PLATE , RAIL
1 REF	P06-052-311	PLATE, RAIL BOW
1 REF	P06-052-312	BAR, RAIL MOUNTING
1 REF	P06-052-313	PLATE, RAIL CYLINDER MOUNTING
1 REF	P06-052-314	PLATE, SLIDE BOW
2 REF	P06-052-315	PLATE, SLIDE END
1 REF	P06-052-316	BLOCK, SLIDE ROLLER
1 REF	P06-052-317	PLATE, TOWER BASE
1 REF.	P06-052-318	PLATE, FEED TOWER GUSSET
1	25-002-00	GREASE COVER YOKE
1	25-004-00	YOKE
4	04-005-00	SEAL
2	04-006-00	BRONZE BUSHING
1	03-007-00	TENSIONING SCREW
1	03-008-01	TENSIONING BRACKET
1	03-009-00	BLADE TENSIONING KNOB
1	25-011-00	BLADE TENSION BAR
1	25-013-00	BLADE TENSIONING BAR HOLDER
1	25-016-00	SAW FRAME
1	04-020-00	BLADE HOLD DOWN CLAMP
1	25-022-00	BLADE HOLDER PIN
1	25-023-00	GUIDE RAIL
1	25-024-00	GREASE SEAL
1	25-026-00	COVER, GEAR BOX

1	25-028-00	CAM FOLLOWER
1	04-101-00	ADAPTER MACHINE DRIVE
1	25-030-00	GEAR
1	04-032-00	GEAR SHAFT
1	25-034-00	PINION
4	90-500-00	GREASE FITTING
1	25-036-00	BEARING
1	25-037-00	BEARING
1	25-038-00	BEARING
1	25-039-00	BEARING
1	25-040-00	DRIVE SHAFT
1	25-042-00	REAR GUARD
2	04-043-01	SHAFT
1	25-044-00	FEED SCREW
1	25-051-00	CAM WHEEL
1	25-052-00	FEED NUT
4	04-053-00	BRONZE BUSHING
2	04-054-00	THRUST BEARING
1	90-215-01	CASTLE NUT
1	04-061-00	CAM FOLLOWER MODIFIED
1	25-068-00	REAR GUARD (L.H.)
1	25-069-00	MAIN FRAME
2	25-070-00	SAW FRAME GUIDE
2	04-074-02	VERTICAL GUIDE SHAFT
1	03-082-00	NAME PLATE
1	25-080-00	BUSING, BEARING PLATE
4	25-095-00	WEAR PLATE
2	04-212-00	BLOCK, BEARING
1		Hydraulic Cylinder 20" stroke
1		Hydraulic Motor
4		FITTING, BULKHEAD -8 JIC(M) x -8 NPT (M)
2		FITTING, BULKHEAD -12 JIC(M) x -12 NPT(M)
4		NUT, BULKHEAD -8
2		NUT, BULKHEAD -12
4		QUICK DISCONNECT, 1/2" NPT(F) x 3/4" BODY MALE W/ FLANGE
2		QUICK DISCONNECT, 3/4" NPT(F) x 3/4" BODY MALE W/FLANGE
2		NEEDLE VALVE, 1/8" NPT
2		FITTING, ADAPTER 1/8" NPT(M) x 1/8" NPT(M) -90 DEG

Fasteners

4		HHCS, 1-1/4"-7 x 2-1/2" LNG.
24		HHCS, 1/2-13 x 1-1/2" LNG.
1		HHCS, 3/4-10 x 1-1/2" LNG.
4		SHCS, 1/2-13 x 2-3/4" LNG.
24		NUT, HEX 1/2-13
48		WASHER, 1/2"
1		WASHER, 3/4"
4		WASHER, 1-1/4"
24		LOCKWASHER, SPLIT RING 1/2"

2		SHCS, 3/4-16 x 2-1/2" LNG	
2		NUT, HEX JAM 3/4-16	
2		HHCS, 1/2-13 x 2-1/2" LNG.	
2		PIN, DOWEL 3/8" DIA x 1-1/2" LNG.	
1		SSS, 5/16-18 x 3/4" LNG (316 STAINLESS STEEL)	
1		NUT, JAM 5/16-18 (316 STAINLESS STEEL)	

P06-052-511 MODEL SUPER D HYDRAULIC AUTOFEED

Quantity	Part No.	Description
1	P06-052-150	HOUSING, FEED BOX OUTPUT
1	P06-052-155	COUPLING MATEX MOTOR
1	P06-052-158	COUPLER, DRIVE
1	P06-052-159	HOUSING, FEED BOX INPUT
1	P06-052-160	YOLK, FEED
1	P06-052-161	BUSHING, FEED CLUTCH
1	P06-052-180	SCREW, SUPER D PLANET FEED
1	P06-052-181B	SPROCKET, 2.40 PITCH x .375 PITCH
1	P06-052-182	SPROCKET, 1.80 PITCH x .375 PITCH
1	P06-052-183	PLATE, SUPER D HYD MOTOR MOUNTING
1 REF	P06-052-184	PLATE, SUPER D GUILLOTINE CHAIN COVER
1 REF		PLANET OUTPUT BLANK - FOR TEST
1		PLANET INPUT BLANK - FOR TEST
1		PLANET SPACER
1		PLANET SET (3:1)
1		PLANET SET (4:1)
1		BEARING (.75 x 1.625 x .438)
1		SNAP RING (3/4" O.D. SHAFT)
4		SNAP RING (1-5/8" I.D. BORE)
1		STANDOFF, 3/8" OD x 5/8" LNG. (SPECIFY 10-24 THD)
1		O-RING -033 2" ID x 2-1/8" OF x 1/16 WIDE
24"		O-RING -041 3" ID x 3-1/8" OD x 1/16" WIDE
1		#35 CHAIN (SS)
1		#35 CHAIN CONNECTING LINK
4		BEARING, SLEEVE 5/8" ID x 23/32" OD x 1/2" LNG
2		WASHER, BELLEVILLE SPRING 2" OD x 1" ID x .065 THICK
1		ZERK, GREASE 1/4-28
		FEED MOTOR

Fasteners

16		SHCS, 8-32 x 1/2" LNG.
7		SHCS, 8-32 x 2" LNG.
1		SHCS, 1/4-28 x 5/8" LNG.
5		SHCS, 1/4-28 x 7/8" LNG.
4		SHCS, 5/16-18 X 5/8" LNG.
4		SHCS, 10-24 x 1-1/4" LNG.
2		SSS, 1/4-20 x 5/16" LNG.
1		PIN, SPRING 3/32" DIA x 3/8" LNG (SS)
1		PIN, CLEVIS 1/4" OD x 1-1/2" LNG. (316SS)
2		KEYWAY 3/16" x 3/4" LNG. ROUND ENDS
4		FHCS, 3/8-16 x 3/4" LNG.
1		PIN, DOWEL 1/4" DIA. X 1-1/4" LNG

P06-052-513 MODEL SUPER D LIFTING FRAME (AUTOCLAMPING FRAME ONLY)

1	P06-052-012	WELDMENT, LIFTING FRAME	
1 REF.	P06-052-319	TUBE, LIFT FRAME BOTTOM	
2 REF.	P06-052-323	PLATE, LIFT FRAME BOTTOM MOUNT	
1 REF.	P06-052-324	TUBE, LONG LIFT FRAME FOOT	
1 REF.	P06-052-325	TUBE, SHORT LIFT FRAME FOOT	
2 REF.	P06-052-320	TUBE, LIFT FRAME ARM	
2 REF.	P06-052-321	CHANNEL, LIFT FRAME ARM	
4 REF.	P06-052-326	PLATE, LIFT FRAME FOOT END	

Fasteners

8		NUT, HEX 1/2-13	
16		WASHER, 1/2"	
8		LOCKWASHER, SPLIT RING 1/2"	
8		HHCS, 1/2-13 x 1-1/2" LNG.	

Chapter 9

Accessories

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The Super D Guillotine can be supplied with the following accessories:

- autofeed drive
- lifting frame
- hydraulic connector bulkhead for topside control .

You should keep a supply of spare blades.

Chapter 10

Ordering Information

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To place an order, request service, or get more detailed information on any E.H. Wachs Company products, call us at one of the following numbers:

U.S. 800-323-8185

International: 847-537-8800

ORDERING REPLACEMENT PARTS

When ordering parts, refer to the parts lists in Chapter 8. Please provide the part description and part number for all parts you are ordering.

REPAIR INFORMATION

Please call us for an authorization number before returning any equipment for repair or factory service. We will advise you of shipping and handling. When you send the equipment, please include the following information:

- Your name/company name
- Your address
- Your phone number
- A brief description of the problem or the work to be done.

In This Chapter

ORDERING REPLACEMENT PARTS

REPAIR INFORMATION

WARRANTY INFORMATION

RETURN GOODS ADDRESS

Before we perform any repair, we will estimate the work and inform you of the cost and the time required to complete it.

WARRANTY INFORMATION

Enclosed with the manual is a warranty card. Please fill out the registration card and return to E.H. Wachs Company. Retain the owner's registration record and warranty card for your information.

RETURN GOODS ADDRESS

Return equipment for repair to the following address.

E.H. Wachs Company

600 Knightsbridge Parkway

Lincolnshire, Illinois 60069 USA

Alpha Rentals, L.L.C.
4706 Curtis Lane
New Iberia, LA 70560
337-367-2880 www.alpha4rentals.com